The second secon	r ID 121429 ~ 5, 2014 2:59:28 PM	L T	1	*121	429*						Page 1
Revision ID:	03407-041 'ow Ring	SII		Accept	*N900	040	100)* s	etup Start Stop	171.	S1* S2*
Start Date: 7 Required Date: 7 Reference:		y: 10.00 ty: 10.00	*10* *10*	1	Cust Item I Customer:	D:				"IN:	77°
Approvals:	Process Plan: MC	5	Date: 14-00-7	7 Tooling:	D	ate:	=:	R	un Start	~1	R1*
	QC:		Date:	_ SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operatio Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										Same
D3407	Rev E										
100-	Large Fab			0.00							
100 Large Fab		Memo		0.00				10	a	14%	1-2/
Large ifab		Weld £3407-1/	7-5 using welding rod 74 ROD Batch:	FIG174 as per Dwg D3407	& QSI 004						
110	QC9- Inspe	ect visual per QSi	1004- Fusion Welds	0.00							046
110		The second se	10 Fe 6 17							00	DAS 9
QC Quality Control		Memo		0.00				(10)	14-07	-82	9-80
- Control											
120	QC5- Inspe	ect part complete	ness to step on W/O	0.00							
120 QC Quality*Control		Memo		0.00				(a)	14-07.	99	DAS 9 9-88
Quality Control											3-08

DQA:		Date:			Y							"DART
					WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:				_	- 4		W	ork Order up	date only	
Work Order:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
WORK Order.					Rework	1		Skid-tube Crosstube		1	Water Jet	Engineering
Part No.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
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	Bending				Bend		Folio/F	Program		Outside Dim		Pressure/Forced
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	Cracks				Broken/Damage/Defect		Hardwa			Part Incorre	_	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		The state of the state of	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		-	tions Incomplete/Unclear	_	Part Moved	L	Wrong Stock Pulled
_	Crushing				Countersink		- S	gned/off center	_	Positioned V		7
_	Heat Trea				Cut Too Short	-	Mislab		L	Power Loss/	Surge	Other
<u> </u>	Inspectio		Tube		Drawing		Misrea					
	Marks/Ch				Drill Holes	-	Off-set					
_	Turning Sequence				Finish	-	-	Calibration		·		
	Turning Sequence Wave/Twist in Tube				Fit/Function		Out of	Sequence				

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Work Order ID 121429

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121429

Page 2

Item-ID: D3407-041 Accept *N900040100* Setup Start Revision ID: Item Name: Tow Ring Start Date: 7/15/14 Start Otv: 10.00 *10* Cust Item ID: Required Date: 7/15/14 Reg'd Otv: 10.00 *10* Customer: Reference: Start Run Approvals: Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Plan Tool ID Accept Reject Reject Insp. Work Center ID Description Run Hours Code Oty Qty Number Stamp 130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00 *120* Powdercoat 0.00 Memo Powder Coating ** Mask Threaded Rection ** START TIME: JOS OVEN TEMPERATURE: FINISH TIME: 3 DAS 140 QC3- Inspect Part Finish 0.00 41 *140* 10 OC Memo 0.00 14-7-23 Quality Control 150 Identify as per dwg & Stock Location: 0.00 DAS *150* 32 57530 Packaging Memo 0.00 Packaging.

DQA:		Date:										DART
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					Use-as-is		Therr	noforming Finishin		Rec/Stor	re/Packaging	Other
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Work Order ID 121429

Quality Control

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121429

Page 3

Item ID: D3407-041 Accept *N900040100* Setup Start Revision ID: Item Name: Tow Ring Stop Start Date: 7/15/14 Start Oty: 10.00 *10* Cust Item ID: Required Date: 7/15/14 Reg'd Oty: 10.00 *10* Customer: Reference: Start Run Approvalsa Process Plan: Date: Tooling: Date: Stop OC: Date: SPC (Y/N): Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Insp. Work Center ID Description MJ 1407-24 MJ 1407-24 14-7-24 Run Hours Code 160 QC21- Final Inspection - Work Order Release 0.00 *160* QC 0.00 Memo

DQA:			Date:											DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPD			_	_	AEROSPACE
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	_	Crimp/Kink/Ripple/Wave Cuffs				Contamination		-	tions Incomplete/Uncl		Part Moved		$\overline{}$	Wrong Stock Pulled
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		Turning Sequence				Finish		-	Calibration					
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Thursday, June 26, 2014 2:59:28 PM

Work Order ID: 121429

121429

Parent Item:

D3407-041

D3407-041

Parent Item Name: Tow Ring

Start Date: 7/15/14

Required Date: 7/15/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

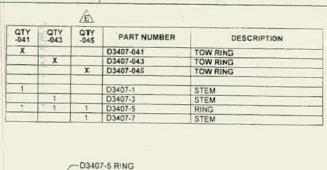
IPP Rev:A05.10.14New issueKJ/EC

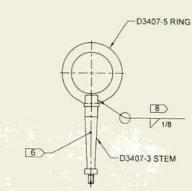
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
⁰³⁴⁰⁷⁻¹ *∏.3407-1* _{Stem}		Manufactured	No			100	Each	57.0000	**	10 E	/5	4-7-3)/
D3407-5 *D.3407-5* Ring		Manufactured	No		103869 113621 116814	Loc 100	57 6 10 41 Each	<u>Loc Code</u> 31.0000	**	6 4 10 A		9.7-ê	o/
				Location WA001	113761 115097 115804	<u>Loc</u>	Oty 31 20 3 8	Loc Code	-				

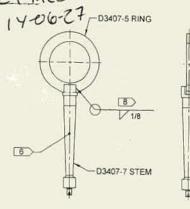
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	Turning S				Finish		A CONTRACTOR OF THE PARTY OF TH	Calibration				
	Wave/Tw				Fit/Function		-	Sequence				

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SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 121429 MCJ





03407-041 TOW RING

(8) 1/8

-D3407-1 STEM

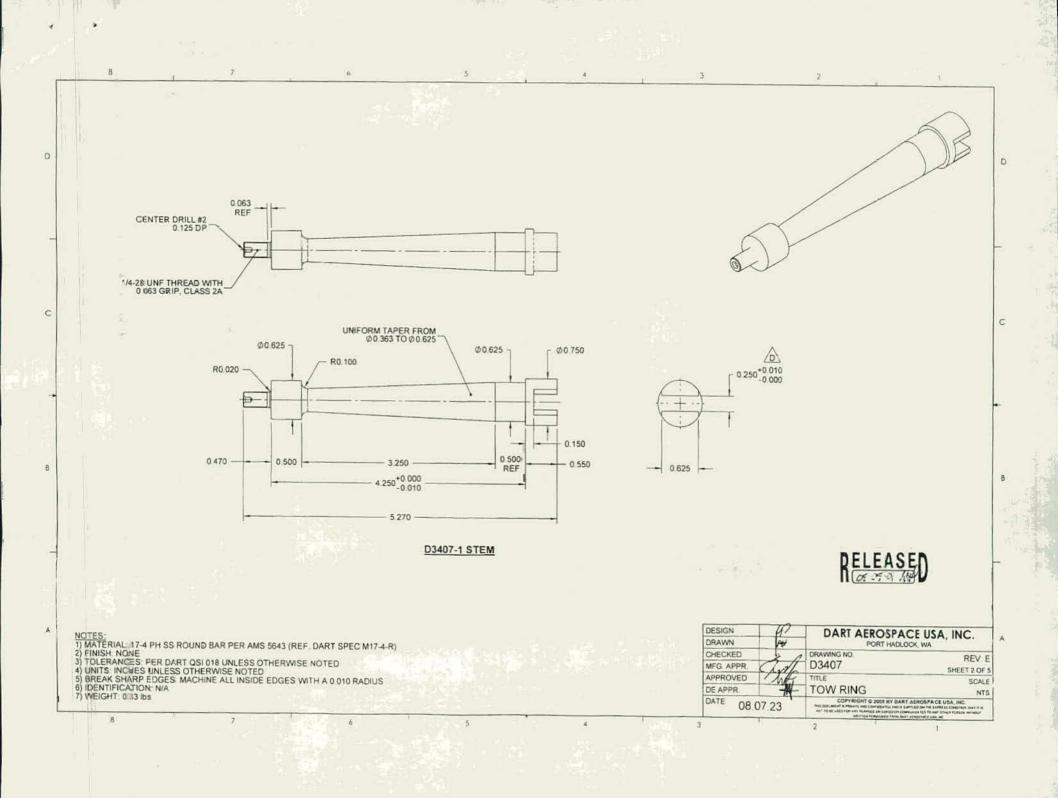
D3407-043 TOW RING

D3407-045 TOW RING

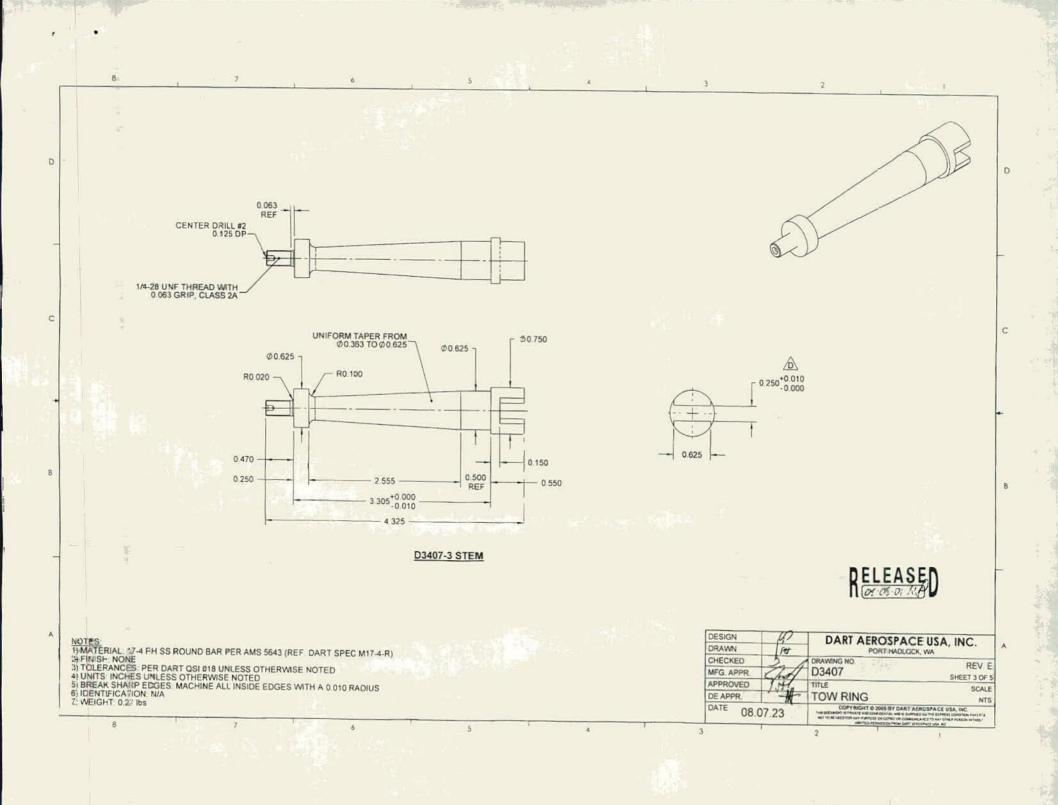
CHECK MFG /	KED	Per	DRAWING NO. D3407	, WA	REV E
DESIG		191	DART AEROSPACE	USA	, INC.
REV.			DESCRIPTION	BY	DATE
A	NEW ISS	UE		CP	05.03.16
В	UPDATE	DIAME ER	THREAD CLASS ADDED	CP	05.05.17
C	THE RESERVE AND PARTY AND PARTY.	The second second	IT WWASHER	CP	05.09.09
0	D3407-1/ WITH D3 FLAT ON B6-4); RE	-3 SLOT WA 407-5 (ZN C ONE END F ASON: PRO	S ROUND NOW FLAT FOR ASSEMBLY 2-2, C2-3); D3407-5 WAS ROUND NOW "OR ASSEMBLY WITH D3407-1/-3 (ZN DUCTION FACILITY	РН	08.04.07
E	REVISED REASON	07-045 (ZN NOTE 5 TO PRODUCT	B2-1, DB-1); ADD D3407-7 (ZN B6-5); O ADD IDENTIFICATION (ZN A5-1); ION FACILITY	PH	08.07.23

NOTES:
1) MATERIAL: N/A
2) FINISH, POWDER COAT WHITE (4.3.5.2) PER DART QSI 005.4.3 (EXCEPT THREADS)
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS CTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER (2) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING
8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

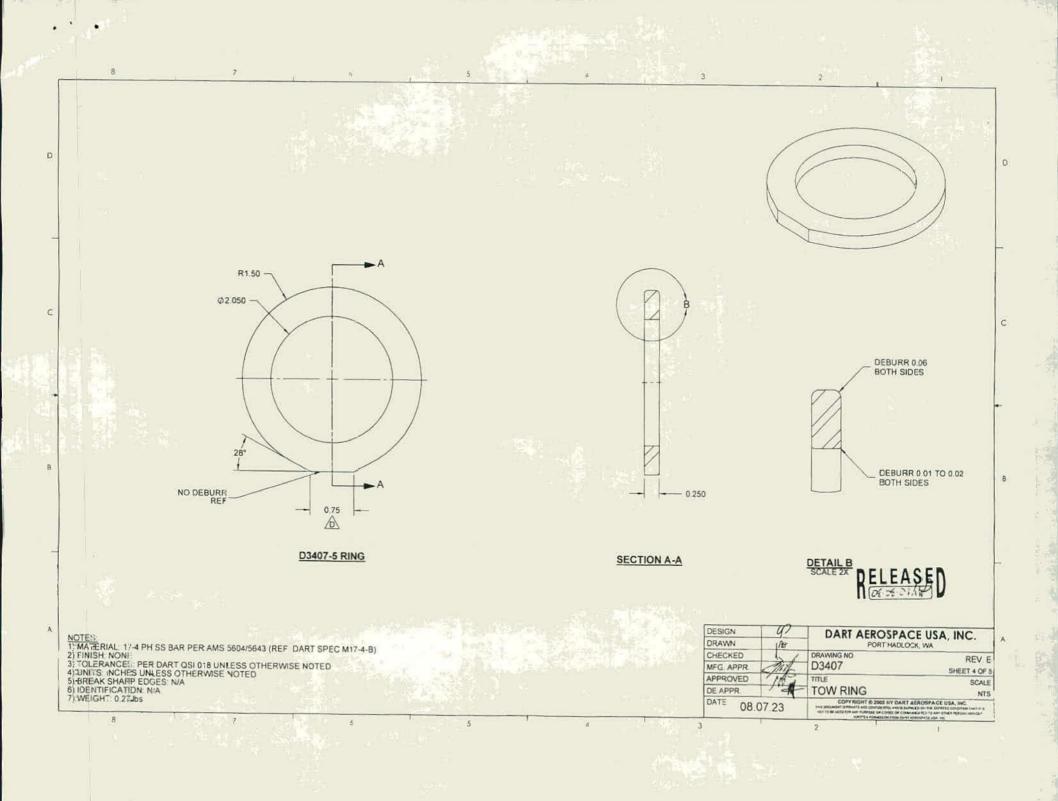
DQA:			Date:										DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			<u> </u>	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	=
	# 925					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
Work Orde	er:				_	Rework	ıÌ		Skid-tube Crosstub		1	Water Jet	Engineering
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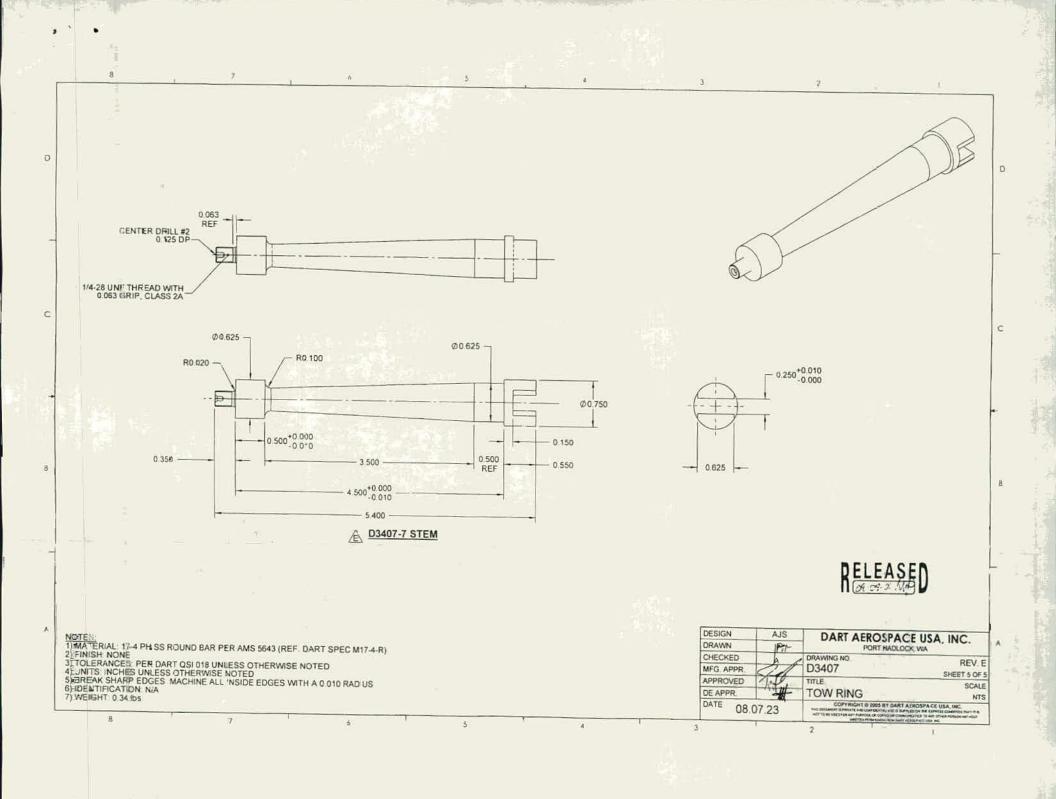
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Part No.					Scrap			Machining Small Fab	$\overline{}$	Pro	d. Eng. Coor.	Quality
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Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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	Centre Not Concentric Cracks				Broken/Damage/Defect		Hardwa			Part Incorred		Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs			ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		7 10 10 10 10 10 10 10 10 10 10 10 10 10	tions Incomplete/Unclear	_	Part Moved	L	Wrong Stock Pulled
	Crushing				Countersink	-		gned/off center	-	Positioned V		٦٠٠٠
	Heat Treat				Cut Too Short	-	Mislabe			Power Loss/	Surge	Other
	Inspection Strip in Tube				Drawing	-	Misrea					
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DQA:			Date:											DART
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QA Closed:			Date:							W	ork Order up	date only		
W-10-4-						DISPOSITION			AGAII	NST DE	PARTMENT	PROCESS		
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Part N	0					Scrap			Machining Small		Pro	d. Eng. Coor.	— ~	Quality
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		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set	-up
	Centre Not Concentric Cracks					Broken/Damage/Defect		Hardwa	re		Part Incorred	i	Ten	nperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Unqualified		Part Lost/Mi	ssing	We	ld
	Cuffs					Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wr	ong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Oth	er
		Inspection	n Strip in	Tube		Drawing		Misread	1					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of (Calibration					
		Wave/Tw	ist in Tub	96		Fit/Function		Out of S	Sequence					



DQA:		<u> </u>	Date:										*DART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	data anly	AEROSPACE
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